

Work Order ID 148778

July 07, 2016 4:05:20 PM

148778

Page 1

Item ID: D4854-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Bracket (Replaces P/N G13013-6)
 Start Date: 7/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/7/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: TO PAINT OLD GENEVA STOCK THAT WAS ANODIZED

Approvals: Process Plan: SM Date: 7/7/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4854	A

160	White Gloss(Ref:4.3.5.1) per QSI006 4.3-Alum	0.00	START: 10:15.						
160	<u>M 135418.</u>	0.00	OL.T: 320°						
Powdercoat	Memo	0.00	FINISH: 10:45.						
Powder Coating	PULL D4854-3 B104866 X 1		1 1609-7 838						
	PAINT AS PER DRAWING		P.T.O.						

170	QC3- Inspect Part Finish	0.00	DAS 38 9-88						
170		0.00	1						
QC	Memo	0.00	SEP 13 2016						
Quality Control									

180	Identify as per dwg & Stock Location: <u>SKS26</u>	0.00	DAS 38 9-88						
180		0.00	1						
Packaging	Memo	0.00	SEP 13 2016						
Packaging									

DQA: Chit Date: 06/21/2016
SEP 19



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: PAH Date:

Work Order update only ☐

Work Order: <u>148778</u> Part No. <u>D4854-3</u> NCR No. <u>16-6040</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☒ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16-09-07</u>		Step #: <u>160</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval DAS 9 9-89 16-09-09		
Description Work Order Deviation				Disposition					
<u>too much powder coat</u> <u>P.T.O.</u>				<u>Strip and re powder coat</u> <u>M 135418</u> START: 1:10 <u>O.V.T: 320°</u> <u>FINISH: 1:40</u> <u>16-09-13</u> DAS 34 9-89				Completed By <u>16/09/12</u> (41) DAS 15 9-89	
								Lead hand / Supervisor Approval Verification DAS 38 9-89 SEP 13 2016	
								QC / QA Coordinator Approval DAS 16 9-89 16/09/12	
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☒ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER :									

Work Order ID 148778

July 07, 2016 4:05:20 PM

148778

Page 2

Item ID: D4854-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Bracket (Replaces P/N G13013-6)
Start Date: 7/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/7/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: TO PAINT OLD GENEVA STOCK THAT WAS ANODIZED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

SEP 14 2016

DAS
21
9-89

SEP 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

July 07, 2016 4:05:24 PM

Page 1

Work Order ID: 148778

148778

Parent Item: D4854-3

D4854-3

Parent Item Name: Lower Bracket (Replaces P/N G13013-6)

Start Date: 7/7/2016

Required Date: 7/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4854-3

Manufactured No

Each

12.0000

1

D4854-3

Lower Bracket (Replaces P/N G13013-6)

Location

Loc Qty

Loc Code

st526

12

~~109081~~

12

104 860 X1

SA 7/7/16.

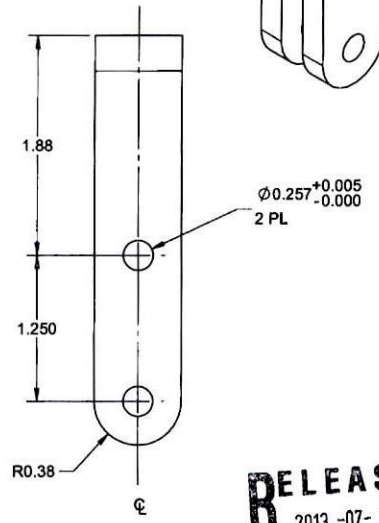
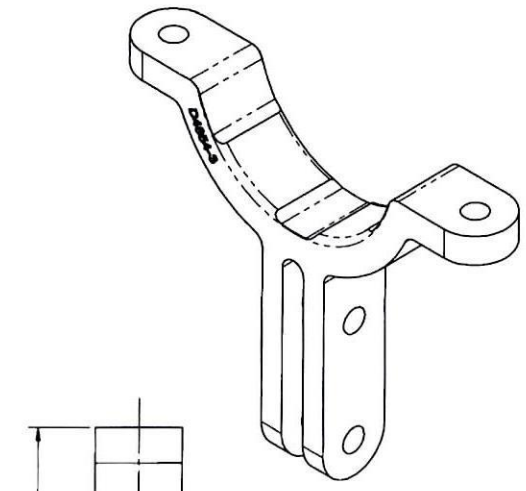
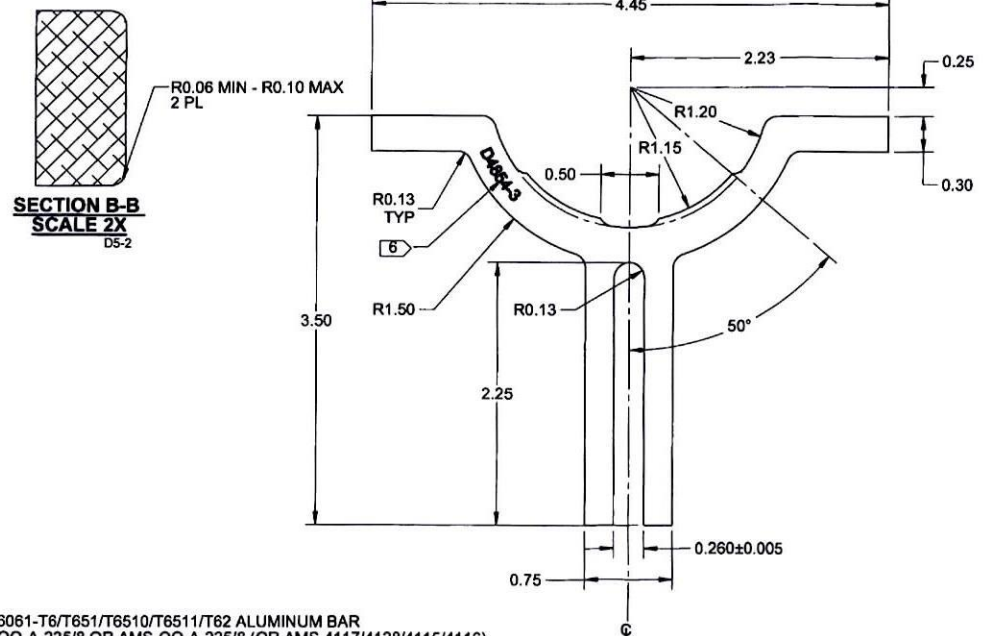
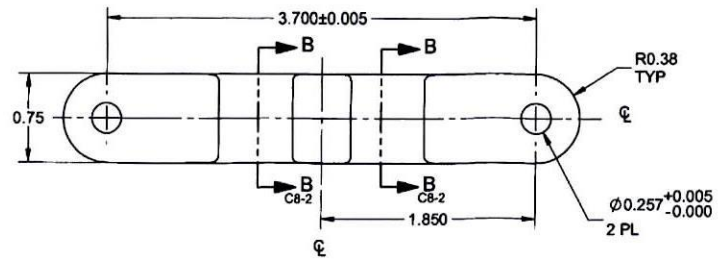
8 7 6 5 4 3 2 1

D

C

B

A



RELEASED
2013-07-16

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AS SHOWN PER QSI 044 6.3 TO A DEPTH
OF 0.010±0.005 IN THIS LOCATION WITH TOOL TIP
RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.19 lbs
- 8) REPLACES GENEVA P/N G13013-6

D4854-3 LOWER BRACKET

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D4854 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		LOWER BRACKET NTS
DATE	13.05.15	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1